

Work Order ID 58108

April 23, 2010 11:47:35 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 23/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 07/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *RP*

Date: 10-4-22 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2580 | Rev D |

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A 70

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

CNC Delta 100 Bender

Memo

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

DP
10-5-4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| A | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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QtyReject
NumberInsp.
Stamp

120



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

10-5-6

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

140

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod

m12860

SE 10/05/06

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod

m12860

SE 10/05/06

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Deburr5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Deburr holes

6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

AWN 10-05-06

10-5-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|---------------------------|
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Page 4

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QtyReject
NumberReject
NumberInsp.
Stamp

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

8.105142

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8.10512

(4)

170



HandFinish

Pressure Wash per QSI005 4.3

0.00

Hand Finishing

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

① BR 10-6-B,

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Page 5

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Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

180



Powdercoat

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Code

Plan

Accept
Qty

Reject

Reject
Qty

Number

Reject
Number

Stamp

Insp.
Stamp

Powder Coating

M1114207

0.00

=> M1

10/05/13

1 0

Powder Coating

Memo
START TIME: 10:00AM
OVEN TEMPERATURE: 320°C
FINISH TIME: 10:30AM

190



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

1 BL 10-5-14

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Page 6

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Stamp

200



HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 M1127029Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291 M1127029Sikaflex expire date: 10/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 114432

① BL 10-5-17.

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Page 7

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Run Start



QC:

Date:

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Stop

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QtyReject
NumberReject
NumberInsp.
Stamp

210



QC

QC5- Inspect part completeness to step on W/O

0.00

S 10/05/10

QW

Quality Control

Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220



Packaging

0.00

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041
Location: RMP 88107
PPP Rev: RMP 88107

230



QC

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

 10/05/2010
 MF
 10-5-19

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NOTE: Date & initial all entries

Picklist Print

April 23, 2010 11:47:39 AM

Page 1

Work Order ID: 58108



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 23/04/2010

Required Date: 07/05/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | |
|---------|--------------|----|-----|------|--------|--------|--|
| D2580-1 | Manufactured | No | 110 | Each | 6.0000 | 1.0000 | |
|---------|--------------|----|-----|------|--------|--------|--|

205 Skidtube bent detail

| | <u>Warehouse</u> <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|---------|--|---------------------------|-----------------|
| B 58090 | Main Warehouse LG 57028 57188 57347 57902 | (1) 6 1 1 2 2 | DP 10-5-4 |

| | | | | | | | |
|---------|--------------|----|-----|------|----------|--------|--|
| D2576-3 | Manufactured | No | 140 | Each | 118.0000 | 1.0000 | |
|---------|--------------|----|-----|------|----------|--------|--|

Step (machining detail)

| | <u>Warehouse</u> <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|--|--|-----------------|-----------------|
| | Main Warehouse LG 46661 52215 | 118 70 48 | SE 10/05/06 |

| | | | | | | | |
|-------|--------------|----|-----|------|----------|---------|--|
| D2579 | Manufactured | No | 140 | Each | 353.0000 | 20.0000 | |
|-------|--------------|----|-----|------|----------|---------|--|

Crossbolt Spacer

| | <u>Warehouse</u> <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|--|--|------------------|-----------------|
| | Main Warehouse LG 57052 57348 | 353 53 300 | SE 10/05/06 |

| W/O: | | WORK ORDER CHANGES | | | | | |
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April 23, 2010 11:47:39 AM

Page 2

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Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 23/04/2010

Required Date: 07/05/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

Required Qty: 1.00

IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

D2855



Manufactured No

200

Each

117.0000 1.0000



Cap

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
|------------------|----------------|-----------------|

Location

Main Warehouse

FP6

2

56613

2

Main Warehouse

ST026

115

50513

1

50770

30

51539 ✓

30

53791

54

AN3-5A



Purchased No

200

Each

1,013.000 2.0000



Bolt

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
|------------------|----------------|-----------------|

Location

Main Warehouse

ST350

1013

105057 ✓

1013

1 DK 10-5-17

2 b 10-5-17

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IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Required Qty: 1.00

AN960JD10L



Purchased No

200

Each

4,415.000 2.0000



Washer

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
|------------------|----------------|-----------------|

Location

Main Warehouse

ST348

4415

2 fl 10-5-17

110985

4415

11

ALS7-1032-130



Purchased

No

200

Each

138.0000 50.0000



Insert

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
|------------------|----------------|-----------------|

Location

Main Warehouse

ST282

114407.

27
23 fl 10-5-17

113238

114654.

138

138

AN3C4A



Purchased

No

200

Each

1,649.000 50.0000



BOLT

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
|------------------|----------------|-----------------|

Location

Main Warehouse

ST350

114523

1649

50. fl 10-5-17.

114103

501

114108

300

114330

348

114416

500

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IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Required Qty: 1.00

AN960C10L



washer

Purchased No 200 Each 0.0000 50.0000

NAS 1149C0332R

114341



50 BL 10-5-17

D3566-13



Gasket

Manufactured No 200 Each 48.0000 1.0000



D3566-5



Gasket

Manufactured No 200 Each 36.0000 1.0000



1 BL 10-5-17

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

48

53461 ✓

48

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP015

36

56829

4

57526 ✓

12

57682

20

1 BL 10-5-17

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|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Page 5

April 23, 2010 11:47:39 AM

Work Order ID: 58108



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 23/04/2010

Required Date: 07/05/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Required Qty: 1.00

D3566-1



Manufactured No

200

Each

49.0000

2.0000



Gasket

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
|------------------|----------------|-----------------|

Location

Main Warehouse

FP015

49

57257

13

57715

36

2 Bl 10-5-17

D3564-11



Manufactured No

200

Each

9.0000

1.0000



Wearshoe

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
|------------------|----------------|-----------------|

Location

Main Warehouse

FP19 57857

9

57259

9

1 Bl 10-5-17

D3564-13



Manufactured No

200

Each

29.0000

1.0000



Wearshoe

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
|------------------|----------------|-----------------|

Location

Main Warehouse

FP17

29

56533

17

57684

12

1 Bl 10-5-17.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Page 6

April 23, 2010 11:47:39 AM

Work Order ID: 58108



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 23/04/2010

Required Date: 07/05/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Required Qty: 1.00

D3564-9



Manufactured No

200

Each

20.0000

1.0000



Wearshoe

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
|------------------|----------------|-----------------|

Location

Main Warehouse

FP 1

55334 1

Main Warehouse

FP019 19

57260 8

57685 11

1 BK 10-5-17.

D3564-5



Manufactured No

200

Each

16.0000

1.0000



Wearshoe

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
|------------------|----------------|-----------------|

Location

OFFSHORE

FG 57729 2

34806 2

Main Warehouse

FP 2

55333 2

Main Warehouse

FP19 12

57525 12

1 BK 10-5-17.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Page 7

April 23, 2010 11:47:39 AM

Work Order ID: 58108



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 23/04/2010

Required Date: 07/05/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

Required Qty: 1.00

IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

D2594-3



Manufactured No

200

Each

171.0000

16.0000



O-Ring, 205 Skidtube

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
|------------------|----------------|-----------------|

Location

Main Warehouse

FP 58191

171

16 - BL10-5-17

55546

171

D2594-1



Manufactured No

200

Each

600.0000

16.0000



Plug, 205 Skidtube

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
|------------------|----------------|-----------------|

Location

Main Warehouse

FP

600

42807

112

55002

282

57826

206

16 - BL10-5-17.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|---------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval, QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART

| | | | |
|---------------------|-----------------------|--|------------------------|
| DESIGN <i>#</i> | DRAWN BY <i>PH</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>#</i> | APPROVED <i>#</i> | DRAWING NO. D2580 | REV. D SHEET 1 OF 3 |
| DATE 07.02.27 | | TITLE 205 SKIDTUBE ASSEMBLY | SCALE NTS |
| A | 96.09.16 | NEW ISSUE | |
| B | 96.12.02 | AS MANUFACTURED | |
| C | 98.08.26 | REDRAWN, INCLUDED DEO 9094/9097 | |
| D | 07.02.27 | CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183 | |

RELEASED
07.06.28 #

| QTY -041 | QTY -045 | Part Number | Description |
|-------------|-------------|---|-------------------|
| X | | D2580-041 | SKIDTUBE ASSEMBLY |
| | X | D2580-045 | SKIDTUBE ASSEMBLY |
| | | | |
| 1 | 1 | D2500-1-190 | EXTRUSION |
| 1 | 1 | D2576-3 | STEP |
| 20 | 24 | D2579 | CROSS BOLT SPACER |
| 16 | 16 | D2594-1 | PLUG |
| 16 | 16 | D2594-3 | O-RING |
| 1 | 1 | D2596 | 205 WEB |
| 1 | 1 | D2855 | AFT CAP |
| 1 | 1 | D3564-5 | WEARSHOE |
| 1 | 1 | D3564-9 | WEARSHOE |
| 1 | 1 | D3564-11 | WEARSHOE |
| 1 | 1 | D3564-13 | WEARSHOE |
| 2 | 2 | D3566-1 | GASKET |
| 1 | 1 | D3566-5 | GASKET |
| 1 | 1 | D3566-13 | GASKET |
| | | | |
| 50 | 50 | ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AEIS-1032-130 | INSERT |
| 50 | 50 | AN3C4A | BOLT |
| 2 | 2 | AN3-5A | BOLT |
| 50 | 50 | AN960C10L | WASHER |
| 2 | 2 | AN960JD10L | WASHER |

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER #
NO. 58108

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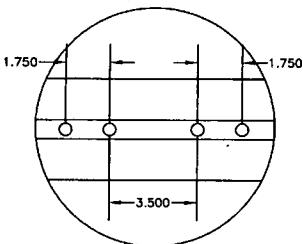
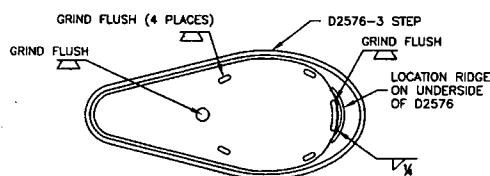
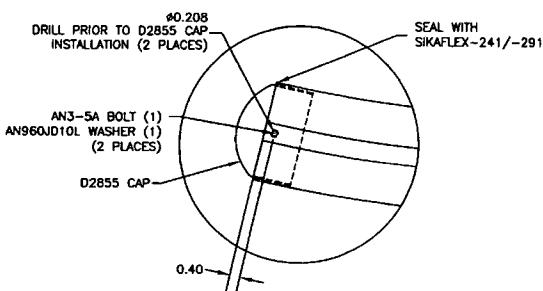
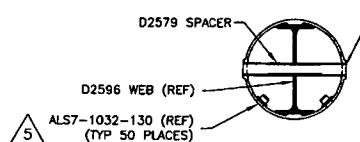
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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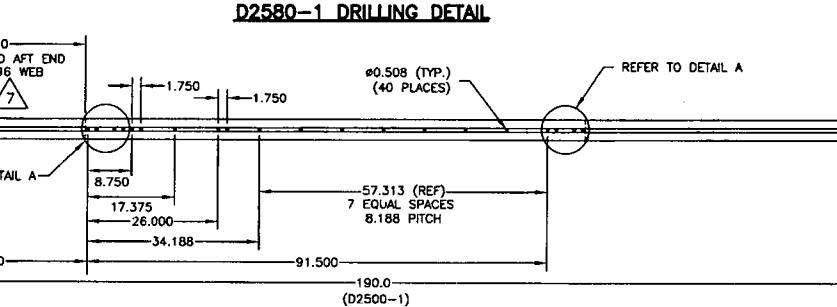
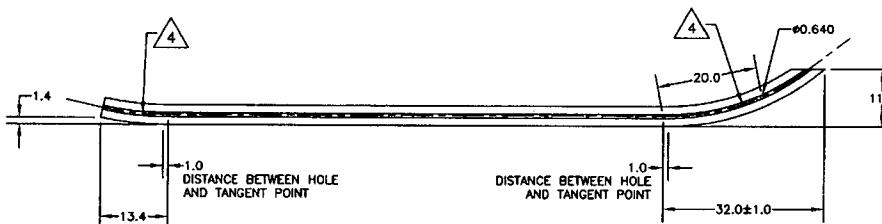
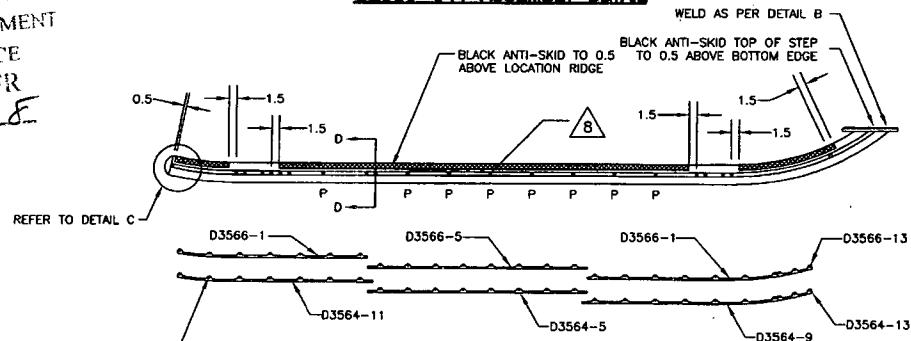
NOTE: Date & initial all entries

DETAIL A
SCALE 5:24**DETAIL B**
SCALE 5:24RELEASED
07-06-28**DETAIL C**
SCALE 5:24**SECTION D-D**
SCALE 5:24

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58108

**D2580-1 BENDING AND CUTTING DETAIL****D2580-041 ASSEMBLY DETAIL****D2580-041 NOTES**

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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|----------|----------|--------------------------------|--|
| CHECKED | APPROVED | | REV. D D2580 |
| DATE | | | SHEET 2 OF 3 |
| 07.02.27 | | TITLE 205 SKIDTUBE ASSEMBLY | SCALE 1:24 |

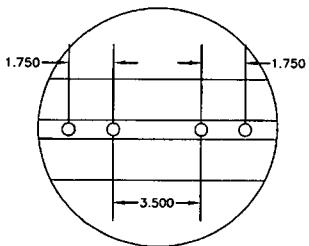
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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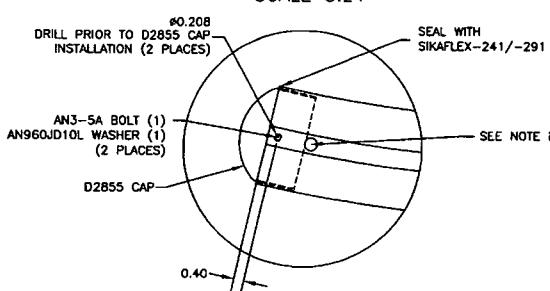
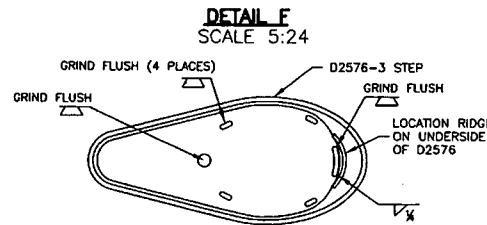
NOTE: Date & initial all entries

DETAIL E
SCALE 5:24

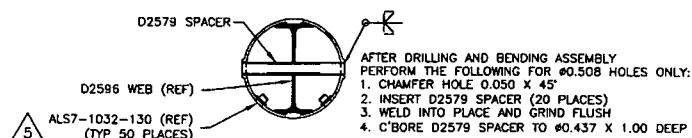


RELEASED
07-06-28

DETAIL F
SCALE 5:24



SECTION H-H
SCALE 5:24

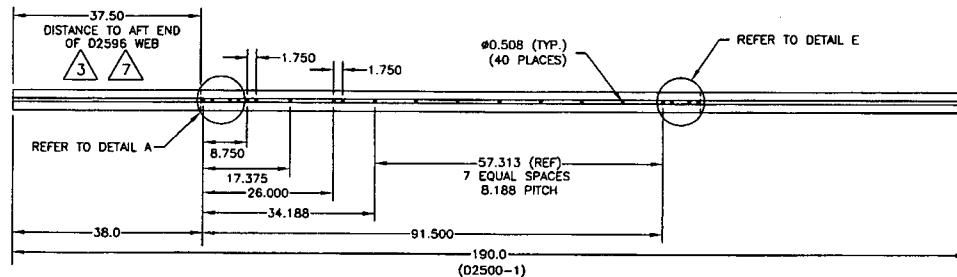


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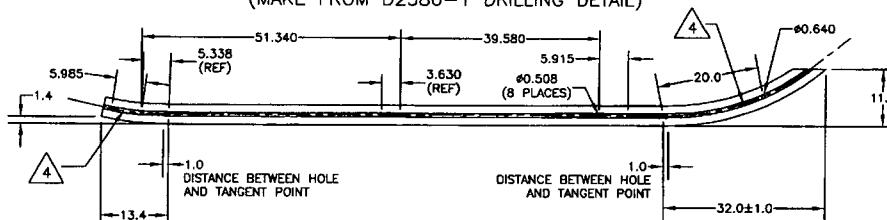
D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

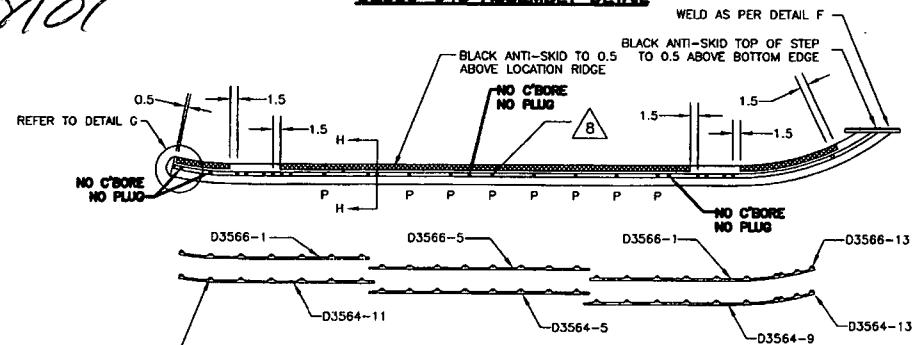
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

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|----------|-----------------------|-------|--|
| RE | RE | | REV. D |
| CHECKED | APPROVED | | SHEET 3 OF 3 |
| | | D2580 | |
| DATE | TITLE | SCALE | |
| 07.02.27 | 205 SKIDTUBE ASSEMBLY | 1:24 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | | |

NOTE: Date & initial all entries

NO: 230

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 576830
Part number: D205-634.041
Description: D205 skid tube
Welding Process: Tig[] Mig[]
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[] fail[]
Penetration: pass[] fail[]

UNACCEPTABLE

Cracks: pass[] fail[]
Undercut: pass[] fail[]
Pin holes: pass[] fail[]
Overlap (cold lap) pass[] fail[]
Porosity (surface): pass[] fail[]
Coloration: pass[] fail[]

Qualifier Barclay Elliott Date of Test Coupon 10.04.27

Welder Barclay Elliott Date of Test Coupon 10.04.27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld